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D3490-3

Job Sheet 197883



Part No: D3490-3

Job Qty: 40 pcs

Part Name: Cross Bolt Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/30/19

Description:

Type: Stock

Note: DWG REV A IPP Rev:A New Issue 06-03-03 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	40 pcs		7/30/19	0.50	2.00	Hardinge - 1		12/07/22
120	QC 8	40 pcs		7/30/19	0.00	0.00	QC 8 - 12		19-07-23
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
124	Handfinish - 4-1-Assembly-B4B	40 pcs		7/30/19	0.00	0.67	Handfinish - 4 - 1 - B4B		
							Handfinish - 4 - 10 - B4B		
							Handfinish - 4 - 11 - B4B		

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						Handfinish - 4 - 12 - B4B							
						Handfinish - 4 - 13 - B4B							
						Handfinish - 4 - 14 - B4B							
						Handfinish - 4 - 15 - B4B							
						Handfinish - 4 - 2 - B4B							
						Handfinish - 4 - 3 - B4B							
						Handfinish - 4 - 4 - B4B	<i>Be</i>						
						Handfinish - 4 - 5 - B4B							
						Handfinish - 4 - 6 - B4B							
						Handfinish - 4 - 7 - B4B							
						Handfinish - 4 - 8 - B4B							
						Handfinish - 4 - 9 - B4B							
						130 Packaging 3-1 - Stock - B4B	40 pcs	7/30/19	0.00	0.00		Packaging 3 - 1 - B4B	
												Packaging 3 - 2 - B4B	
Packaging 3 - 3 - B4B													
Packaging 3 - 4 - B4B													
Packaging 3 - 5 - B4B													
Packaging 3 - 6 - B4B													
Packaging 3 - 7 - B4B													
Packaging 3 - 8 - B4B													
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Packaging 3 - 19 - B4B													
Packaging 3 - 20 - B4B													
Packaging 3 - 21 - B4B													
Packaging 3 - 22 - B4B													
Packaging 3 - 23 - B4B													
Packaging 3 - 24 - B4B													
Packaging 3 - 25 - B4B													
Packaging 3 - 26 - B4B	<i>Be</i>												
Packaging 3 - 27 - B4B													
Packaging 3 - 28 - B4B													
Packaging 3 - 29 - B4B													
Packaging 3 - 30 - B4B													
Packaging 3 - 31 - B4B													
Packaging 3 - 32 - B4B													
Packaging 3 - 33 - B4B													
Packaging 3 - 34 - B4B													
Packaging 3 - 35 - B4B													
Packaging 3 - 36 - B4B	<i>DAS</i>												
140 QC 21 - SA	40 pcs	7/30/19	0.00	0.00		QC 21 - SA - 21	<i>21</i>	JUL 30 2019					
						QC 21 - SA - 70	<i>9-89</i>						
						QC 21 - SA - 53		JUL 31 2019					

Part Op 100 - Hardinge - 1-TURN AS PER FOLIO FA629 & DWG D3490

Descriptions: 120 - QC8- Inspect parts - second check)

124 - Assemble as per dwg - CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANER

130 - Identify as per dwg & Stock Location: *L6001* ***STOCK IN SKIDTUBE CELL***

140 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.750	6061-T6 Round Bar .750"	10.6400 ft (.266 ea)	100-Hardinge - 1	5175076

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6R0.750	11	32	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	3.085Inches + 0.030 - 0.000	3.115 3.085		
2	Crossbolt Spacer	0.080Inches ± 0.010	0.090 0.070		
3	Crossbolt Spacer	0.050Inches ± 0.010	0.060 0.040		
4	Crossbolt Spacer	45.0Degrees ± 0.0	0.0 0.0		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS	
		Rework Scrap Use-as-is		Cross tube Small Fab Finishing Skid-tube Machining Large Fab Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality	
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator		Pressure/Forced		Positioned Wrong	
Manufacturing Process		Bending		Outside Tolerance	
Equip/Tooling		Crushing		Drawing	
Handling/Preservation		Cracks		Finish	
Material		Crimp/Kink/Ripple/Wave/Twist		Part Lost/Missing	
Product Improvement		Marks/Chatter		Misread	
Process Improvement		Mislabeled			
Human Factors		Other/Details:			